



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 173431



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/21/18

Created By: Logan David

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

173151

Plex 3/1/18 2:40 PM dart.logan.david



Container No: S048883



Part: D350-636-011

Job No: 173431

Serial No/Batch: S048883

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/07/18

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/21/18	3/21/18	0.00	0.00	Start Up Skid tubes-1		3/21/18
110	Skid tubes	1 pcs	3/21/18	3/21/18	0.00	4.55	Skid tubes-4		3/21/18
120	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC10		3/21/18
130	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC5		3/21/18
140	HandFinish	1 pcs	3/21/18	3/21/18	0.00	0.93	HandFinish1		3/21/18
150	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC7-2		3/21/18
160	Skid tubes	1 pcs	3/21/18	3/21/18	0.00	4.55	Skid tubes-4		3/21/18
170	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC10		3/21/18
180	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC5		3/21/18
190	HandFinish	1 pcs	3/21/18	3/21/18	0.00	0.93	HandFinish2		3/21/18
200	SprayPaint	1 pcs	3/21/18	3/21/18	0.00	0.91	Spray Paint		3/21/18
210	QC	1 pcs	3/21/18	3/21/18	0.00	0.00	QC14		3/21/18
230	HandFinish	1 pcs	3/22/18	3/22/18	0.00	0.93	HandFinish4		3/22/18
240	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC5		3/22/18
250	Packaging	1 pcs	3/22/18	3/22/18	0.00	0.00	Packaging1-3		3/22/18
260	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC4		3/22/18
265	DC	1 pcs	3/22/18	3/22/18	0.00	0.00	DC		3/22/18
270	Packaging	1 pcs	3/22/18	3/22/18	0.00	0.00	Packaging3-1		3/22/18
280	QC21-FG	1 Ea	3/22/18	3/22/18	0.00	0.00	QC21		3/22/18

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail A to 0.297" (total of 2 holes per side) 7- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M138613 8- Grind welds flush as per Dwg D2750
 160 - 1- Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4- Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: _____ exp. date: _____ ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 038611 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.
 180 - ***VERIFY C'BOARD IS GOOD***
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____
 210 - Inspect for foreign object per QSI 024
 230 - 1- Install inserts as per Dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: M138613 EXP DATE: 12/10/17 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M113547 5- Coat all exposed fasteners with "LPS Procyon" batch: M113547
 260 - *****ensure antiseize is on AN8C21A bolts*****
 265 - record fwd angle: 99.8 Photocopy blue file and type labels per PPP D350-636-011 CHG 007
 270 - Package as per PPP D350-636-011 Location : FG072

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5043969
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5038835
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5040982
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5000649
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5000649
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5029269
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5057153
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5019397
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	F11137055
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	F1127203
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5053257
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	5040142
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5044324
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5053031
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5047122
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5047737
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5037409
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058407
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5049290
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5047686
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5041206
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5046363
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5046244
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5053037
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5034401
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5044236
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409-121
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5036714
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5022098
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	M138411-121
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5034386
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	F1137167
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5040883
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5052854
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5040973
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5010886
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5025635

002596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	16	0
	D2744	1	28	0
160-Skidtubes	D2739	1	23	0
	D2743	8	119	0
	D3490-1	4	108	0
	D3490-3	4	91	0
230-HandFinish	ALS4-1032-225	38	917	0
	AN3C5A	34	683	0
	AN3C6A	4	162	0
	AN6C44A	4	439	0
	AN8C35A	1	71	0
	D2745	8	89	0
	D3488-041	1	14	0
	D3492-1	8	175	0
	D3492-3	8	128	0
	D3535-25	1	11	0
	D3536-25	1	27	0
	D3537-1	3	147	0
	D3631-1	8	38	0
	D3791-1	1	9	0
	D3793-1	1	15	0
	D3793-3	1	18	0
	D3794-1	1	24	0
	D3794-3	1	52	0
	MS21043-6	4	111	0
	MS21083C8	1	87	0
	NAS1149C0332R	38	4,350	0
	NAS1149C0832R	1	96	0
	NAS1515H3L	4	287	0
	NAS1611-010	8	257	0
	NAS1611-013	8	343	0
250-Packaging	AN8C21A	2	160	0
	D2741	1	77	0
	D3493-1	2	38	0
	D3532-1	2	54	0
	MS21083C8	2	87	0
	NAS1149D0863J	2	165	0

Part Specifications

Specifications could not be found.

Plex 3/1/18 2:40 PM dart.logan.david